

Work Order ID 67517

Saturday, March 26, 2011 9:16:56 AM



Ship gtr
April

Page 1

Item ID: D3172-041

Accept



Setup Start



Revision ID:

Item Name: Basket Base Assembly

Stop



Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *11-03-27* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3172	Rev C								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut Qty 4 D3166-1 as per Dwg D3172 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172 3-Drill holes in D3172-3 as per Dwg D3172 4-Debur & Remove all markings from material 5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1 Debur as r

11-04-04

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

11-04-04

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Similar to

(Handwritten mark)

11-04-04
125

Pressure wash

1 11-4-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67517

Saturday, March 26, 2011 9:16:56 AM



Page 3

Item ID: D3172-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

B 67514

0.00

80 11/04/05

①

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/05

MF

11-04-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Saturday, March 26, 2011 9:16:53 AM

Page 1

Work Order ID: 67517

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly



Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117 Clevis		Manufactured	No			100	Each	24.0000	2	2		Ppl 11.04.04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		24							
				55729		24							
D2232-3 Basket Hinge		Manufactured	No			100	Each	6.0000	2	2		Ppl 11.04.04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		6							
				66894		6							
D2327-3 Spacer Bushing		Manufactured	No			100	Each	25.0000	2	2		Ppl 11.04.04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		25							
				58974		1							
				64920		2							
				66087		2							
				66535		20							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Saturday, March 26, 2011 9:16:53 AM

Page 2

Work Order ID: 67517

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

 Mounting Bracket

Manufactured No

100 Each

38.0000

2 2



Pl 11-04-04

Location

Loc Qty

Loc Code

WA005

38

66500

14

66806

24

Manufactured No

100 Each

0.0000

4 4



B66719

Pl 11-04-04

D3166-1

 Basket Hoop

D3174-1

 Mounting Lug

Manufactured No

100 Each

21.0000

8 8



Pl 11-04-04

Location

Loc Qty

Loc Code

WA005

21

59636

5

66816

16

Purchased No

100 sf

470.0000

48 48



53

SAD 11-03-30

M304EX0.75-16F

 Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA

470.000043

114809

0.000043

115012

150

117197

320

218

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Saturday, March 26, 2011 9:16:54 AM

Page 3

Work Order ID: 67517



Parent Item: D3172-041



Parent Item Name: Basket Base Assembly

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

1,099.377

51

53.68421



Pl 11-04-04

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

WA007

1099.377169

116267

200.4298

116763

898.947369

53.68421

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

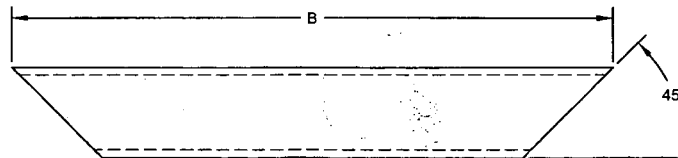
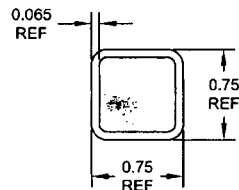
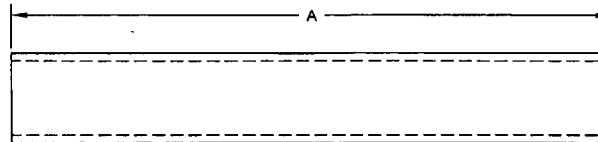
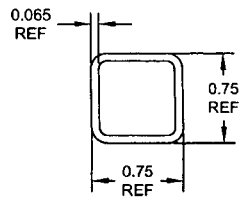
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

M304TS0.750w.065
M116267

PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG



NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. C
CHECKED		D3172	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSEMBLY (EC130)	NTS
DE APPR.		COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE:	08.07.03		

RELEASED
08-08-21/17

#67517

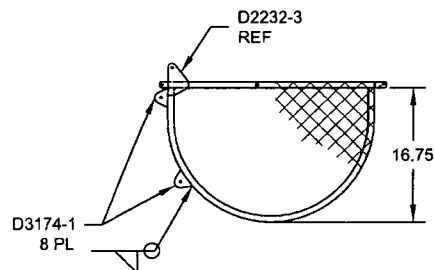
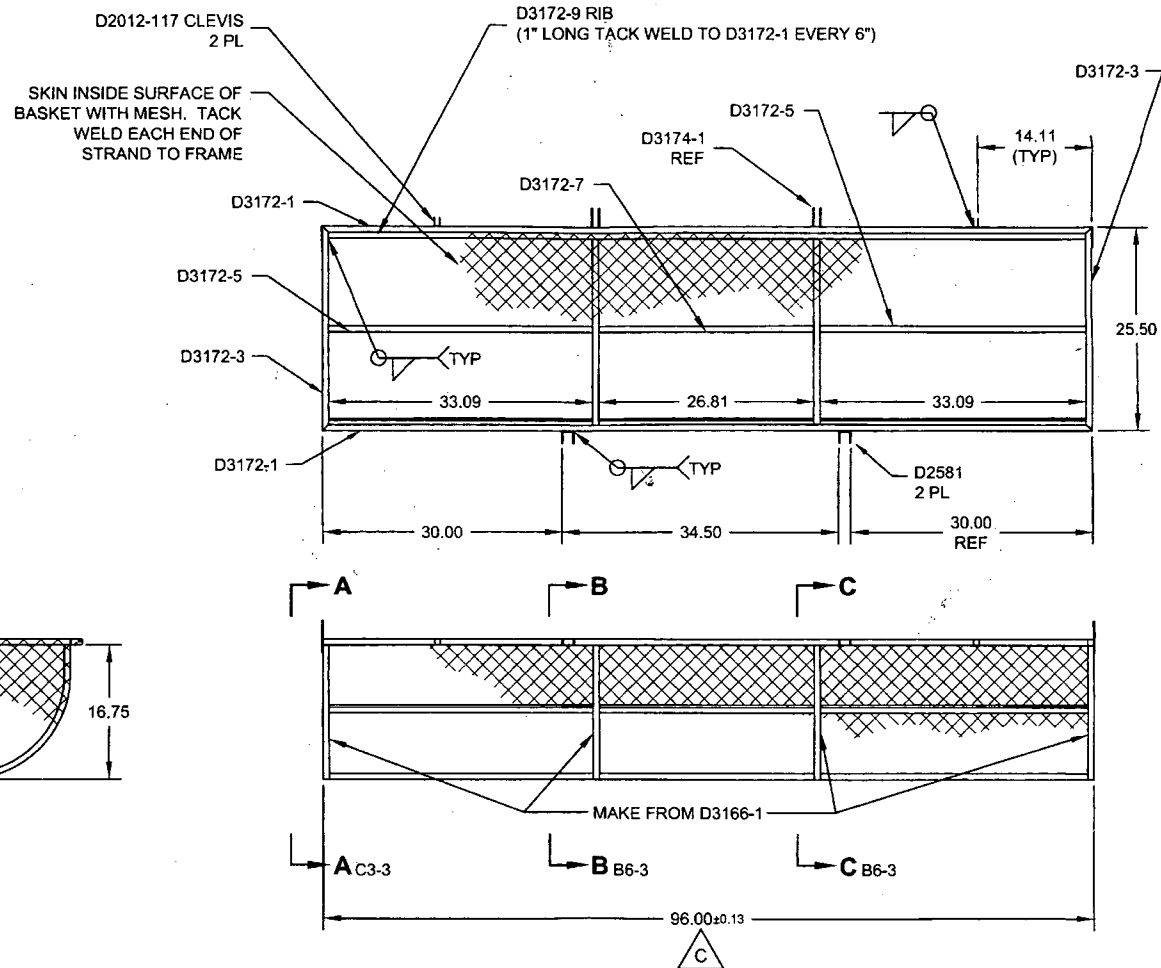
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3172-041 BASKET BASE ASSEMBLY

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3172	REV. C SHEET 2 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSEMBLY (EC130)	NTS
DE APPR.		COPYRIGHT © 2002 BY DART AEROSPACE LTD.	
DATE	08.07.03	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
08.08.04

#67517

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

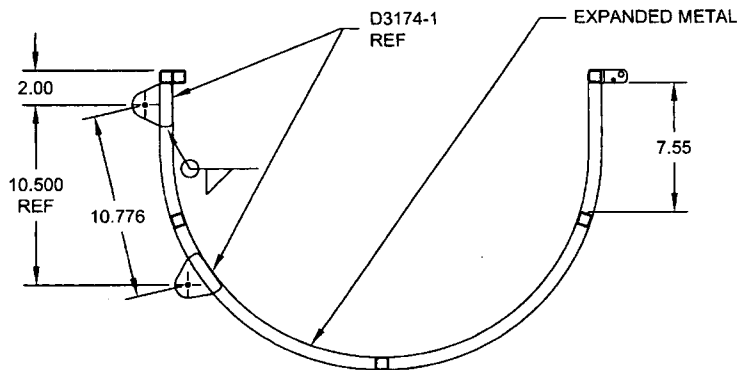
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

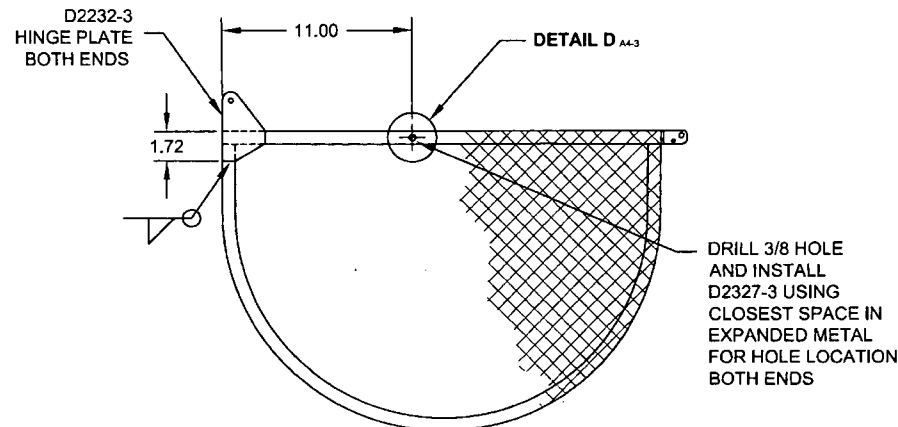
8 7 6 5 4 3 2 1

D

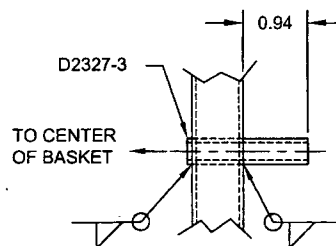
D



**SECTION B-B^{B5-2}
AND SECTION C-C^{B3-2}**
RIB DETAIL
SCALE 2X



SECTION A-A^{B5-2}
SPACER DETAIL
SCALE 2X



DETAIL D^{D3-3}
SCALE 4X

#67517

RELEASED
08-08-21/1140

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

A

A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries